

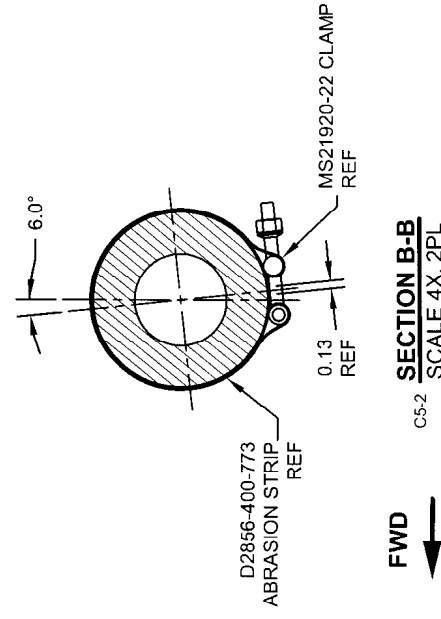
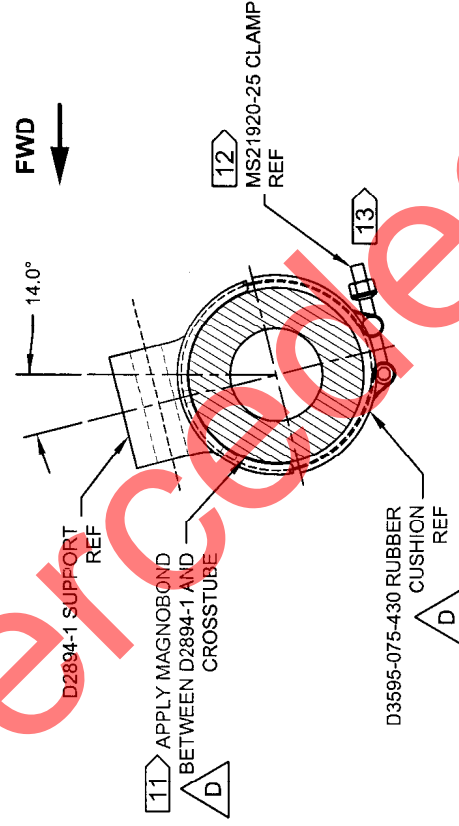
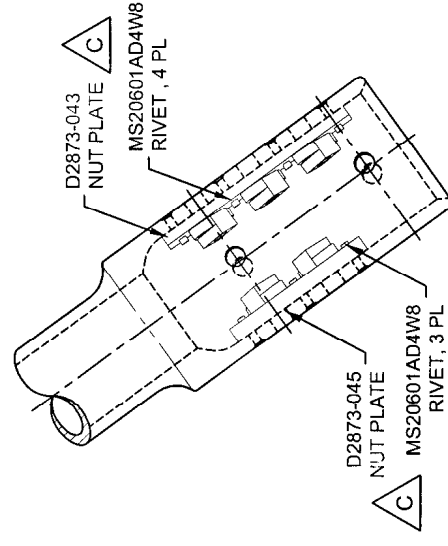
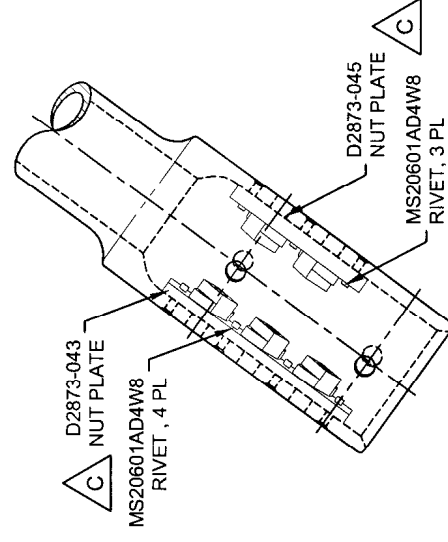
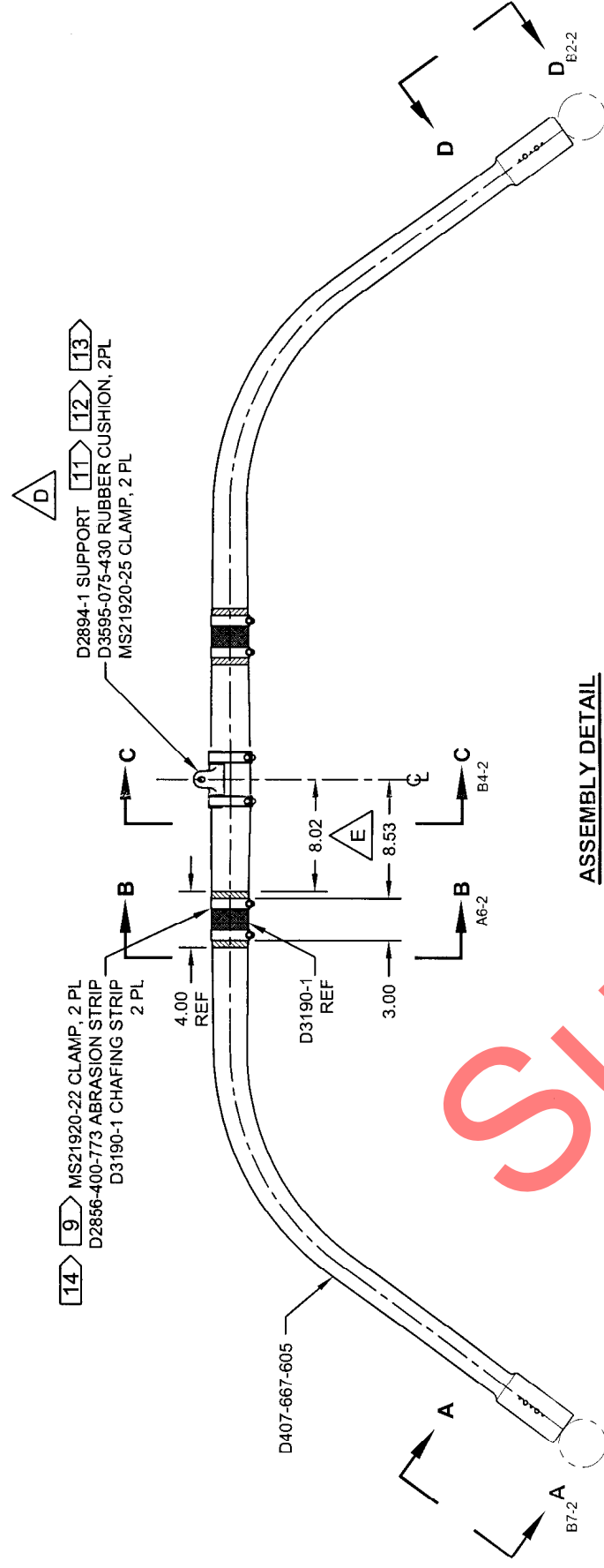
QTY -245	PART NUMBER	DESCRIPTION
X	D407-667-245	CROSSTUBE ASSEMBLY (407 HIGH AFT)
1	D6011-115	CROSSTUBE
2	D2856-400-773	ABRASION STRIP
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
1	D2894-1	SUPPORT
2	D3190-1	CHAFING SHIELD
2	D3595-075-430	RUBBER CUSHION
14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
4	MS21920-22	CLAMP
2	MS21920-25	CLAMP (OR MS21920-24)

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6011-115  
FINISHED LENGTH = 112.91±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 6 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-773 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) INSTALL D2894-1 CENTER SUPPORT USING A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-25 CLAMPS WITH D3595-075-430 RUBBER CUSHIONS TO SECURE D2894-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE SUPPORT.  
NOTE: MS21920-24 CLAMPS CAN BE USED TO ACCOMMODATE VARYING DIAMETERS. ENSURE THERE IS A MINIMUM OF 1.5 THREADS IN SAFETY ON THE NUTS.
- 13) TORQUE CLAMPS 80 TO 100 IN-LB.
- 14) INSTALL D3190-1 CHAFING SHIELDS SO THAT OVERLAP IS ON BOTTOM SIDE OF CROSSTUBE OPPOSITE D2894-1 SUPPORT.

E	8.02 AND 8.53 WERE 8.40 AND 8.90 (ZN D5-2); REORGANIZED VIEWS AND REFORMATED DRAWING TO CURRENT STANDARDS. REASONS: CLAMPS MOVED 0.375 TOWARD CL TO ELIMINATE INTERFERENCE WITH AIRCRAFT MOUNTS. REFERENCE: PAR#08-21 AND ECN#1225	MB	08.07.24
D	ADD VIEW FOR OEM SKID HOLES, ROTATE ORIENTATION OF CLAMPS SECTION F-F, REMOVE -851 ABRASION STRIP, ADD MAGNOBOND 6398, ADD CUSHION	PH	07.02.07
C	ADD HOLES AND NUT PLATES FOR COMPATIBILITY WITH BHT/AA SKIDTUBES	PH	05.07.26
B	ADD CHAFING SHIELD	CP	03.05.21
A	NEW ISSUE	CP	02.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	DART AEROSPACE LTD		
DRAWN	HAWKESBURY, ONTARIO, CANADA		
CHECKED	DRAWING NO.	REV. E	
MFG. APPR.	D407-667-245	SHEET 1 OF 4	
APPROVED	TITLE	SCALE	
DE APPR.	CROSSTUBE ASSY (407 HIGH AFT)	NTS	
DATE	08.07.24	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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08-08-11-17

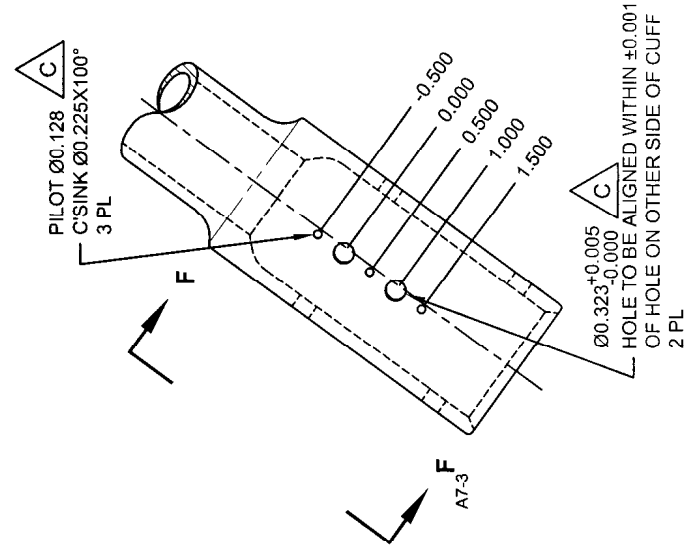


**VIEW A-A CUFF DETAIL**  
SCALE 4X

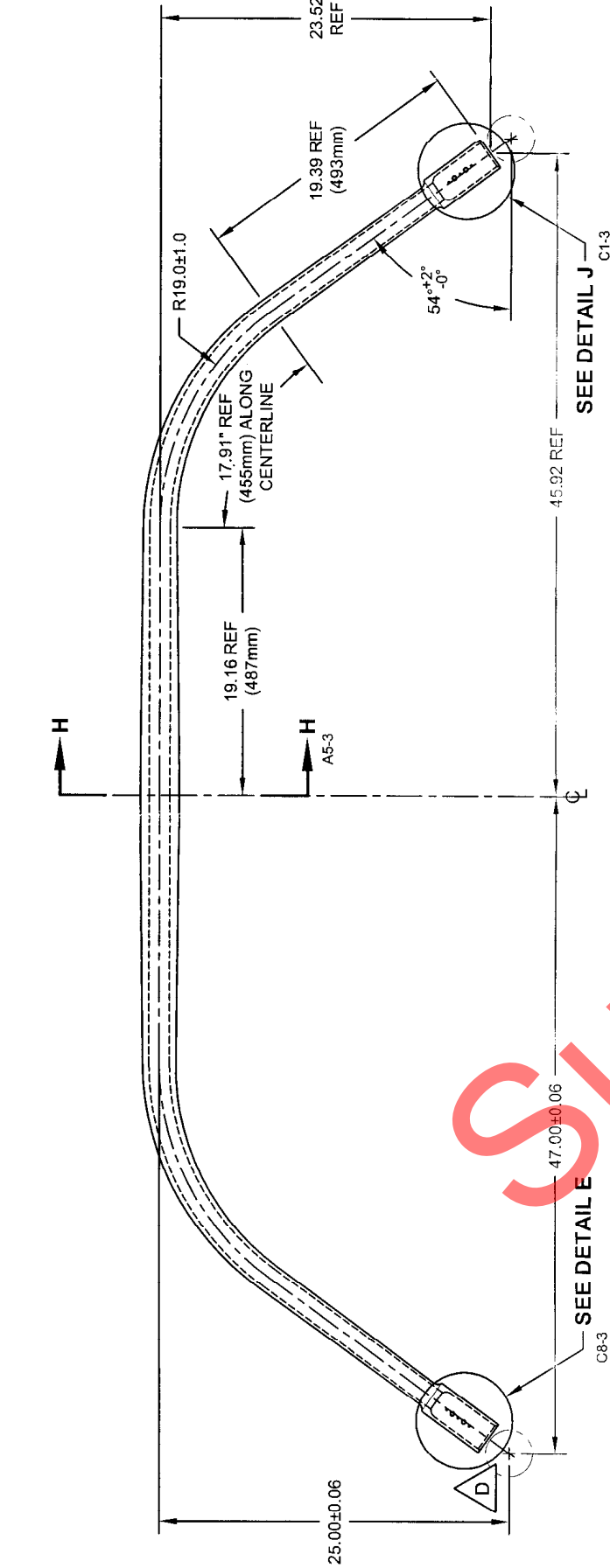
C2-2 **VIEW D-D CUFF DETAIL**  
SCALE 4X

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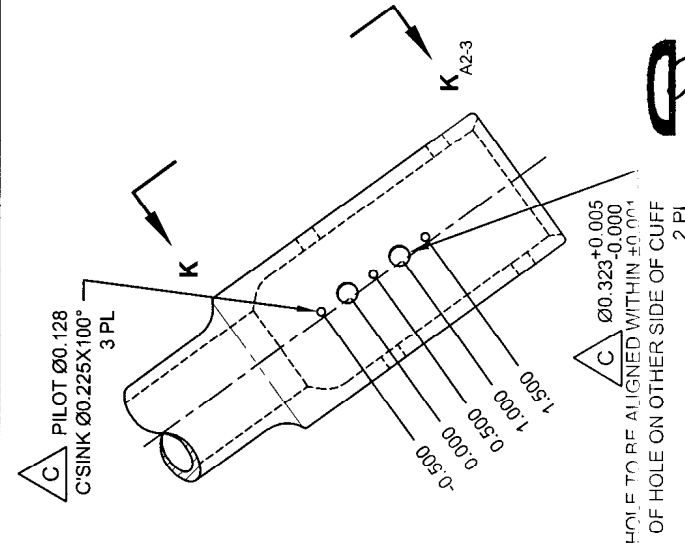
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DATE	08.07.24	TITILE CROSSTUBE ASS'Y (407 HIGH AFT)



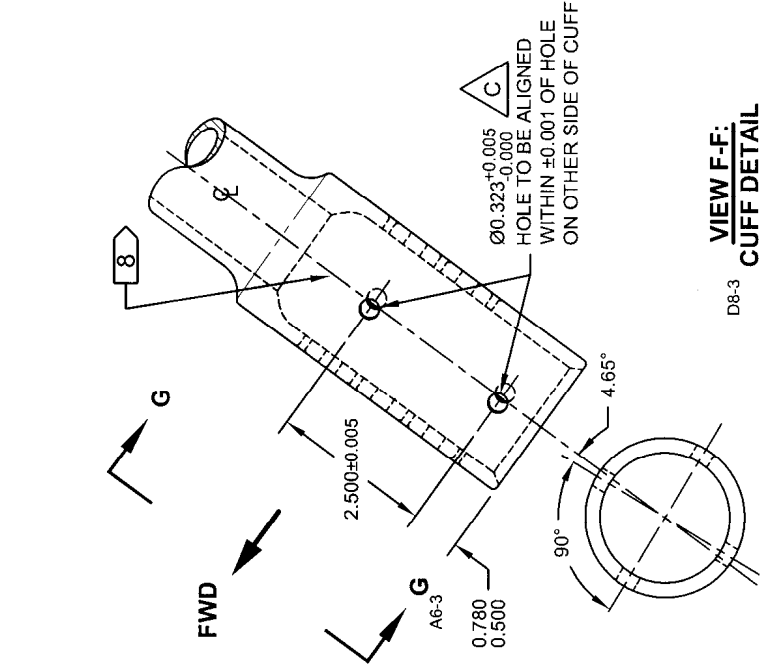
DETAIL E  
SCALE 4X  
(VIEW LOOKING FWD)



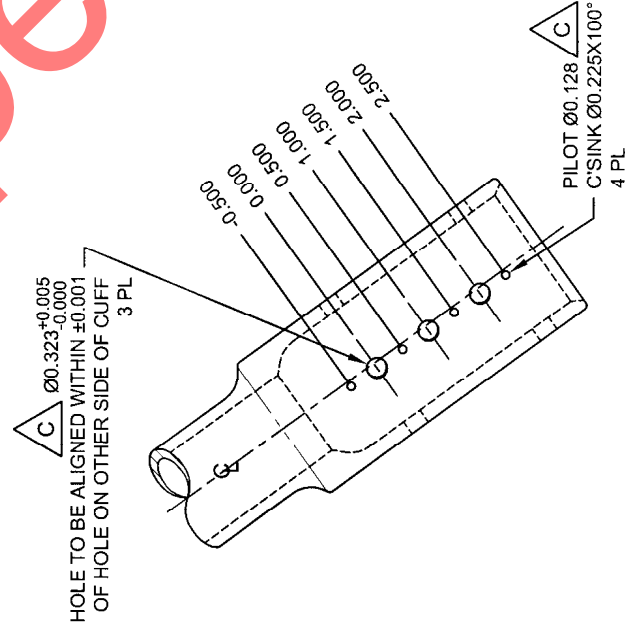
6 BENDING AND DRILLING DETAIL  
(VIEW LOOKING FWD)



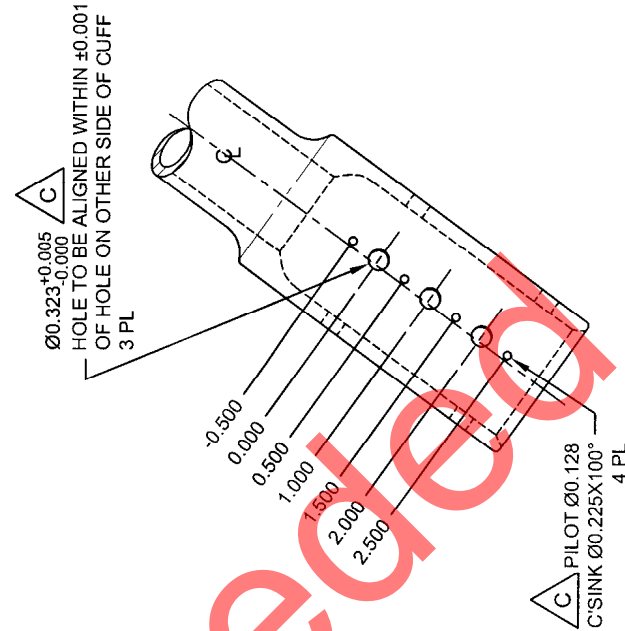
DETAIL J  
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(VIEW LOOKING FWD)



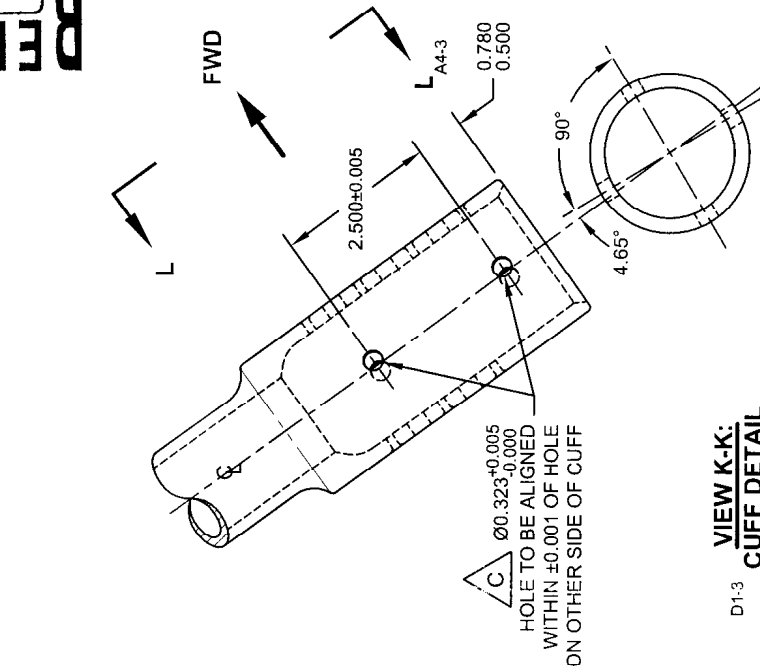
VIEW F-F:  
CUFF DETAIL



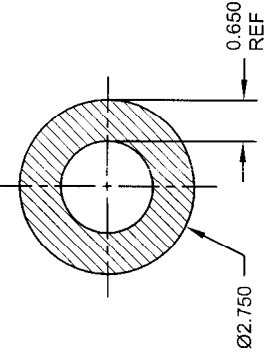
VIEW G-G  
(VIEW LOOKING AFT, ROTATED)



VIEW L-L  
(VIEW LOOKING AFT, ROTATED)



VIEW K-K:  
CUFF DETAIL

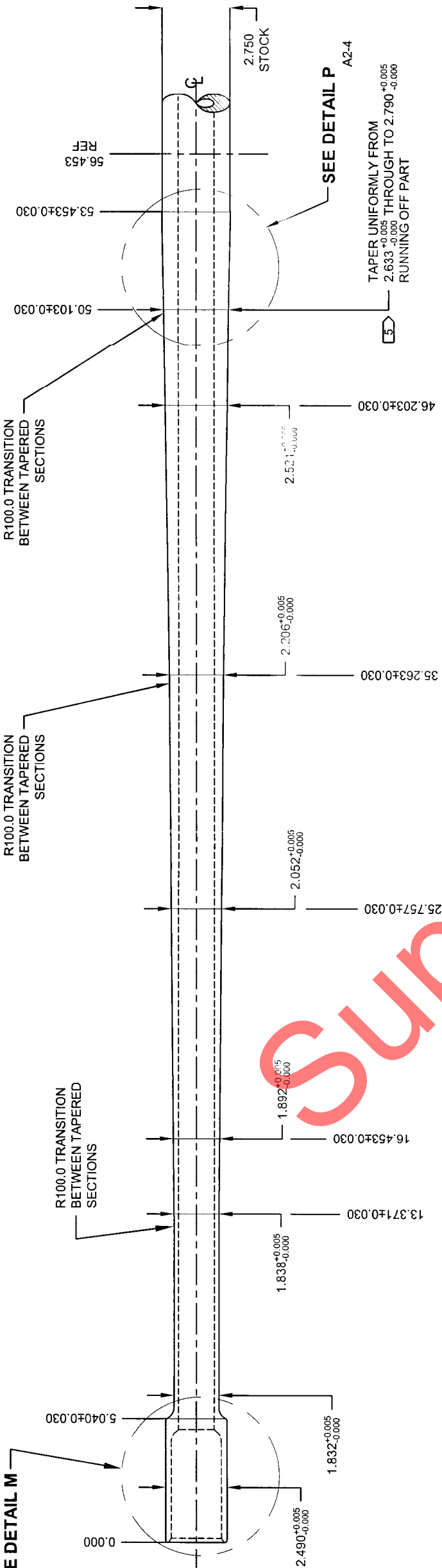


SECTION H-H  
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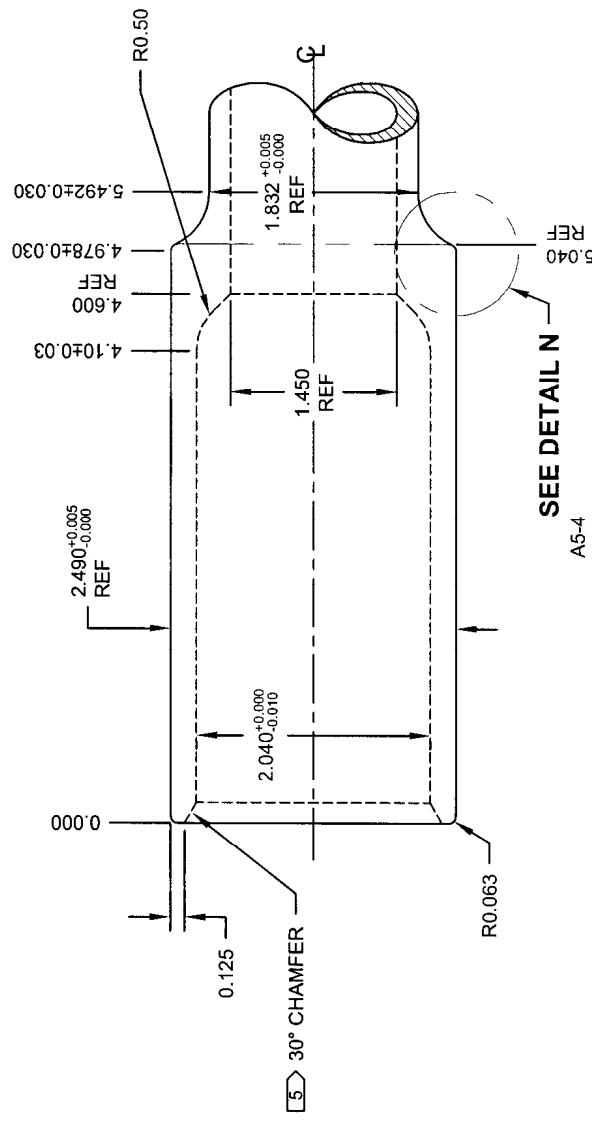
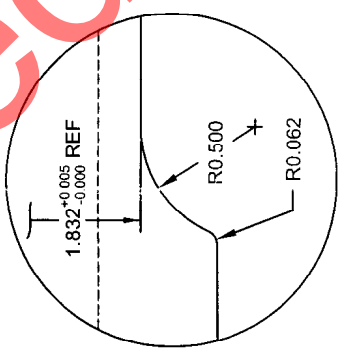
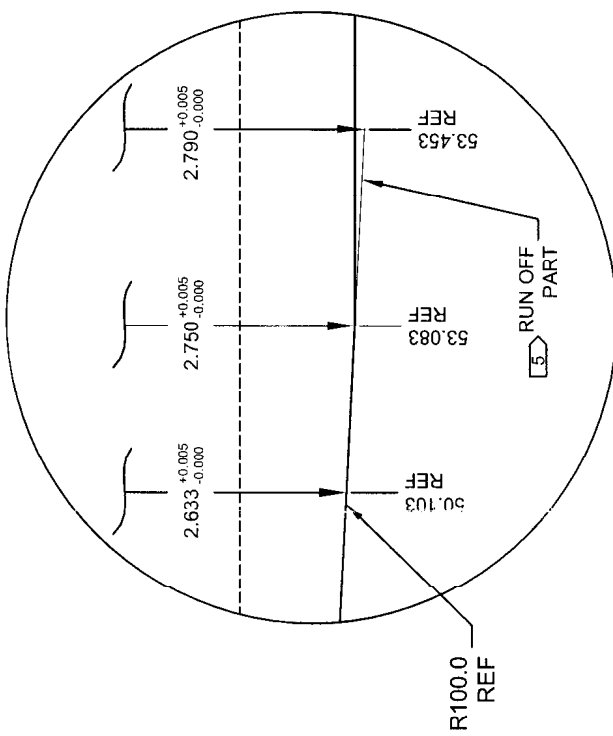
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MFG. APPR.		D407-667-245
APPROVED		TITLE
DE APPR.		CROSSTUBE ASSY (407 HIGH AFT)
DATE	08.07.24	SCALE NTS

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1 2 3 4 5 6 7 8



D407-667-245 MACHINING DETAIL



D8-4 DETAIL M: CROSSTUBE CUFF  
SCALE 3X

B6-4 DETAIL N: CUFF TRANSITION  
SCALE 2X

C1-4 DETAIL P: TAPER RUN-OFF  
NOT TO SCALE

RELEASED  
08.07.24

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DRAWING NO. D407-667-245					
REV. E SHEET 4 OF 4					
TITLE CROSSTUBE ASSY (407 HIGH AFT)					
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